

Wednesday, June 09, 2010 1:13:49 PM



Accept



Setup Start



Stop



Start Date: 6/9/2010 **Start Qty:** 2.00

**Cust Item ID:**

Required Date: 6/24/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-6-09

Tooling:

Date:

Run Start



QC:




Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3180	Rev B								
100		0.00							
	NC BRAKE								
Brake NC									
Brake NC	Memo	0.00							
	1-Punch 304/316 Seamless Tubing with 3/4" O.D. x 0.049" wall to length as per Dwg D3180 using DT8313								
	B-B as per Dwg. D3180								
110		0.00							
	Small Fab								
Small Fab									
Small Fab	Memo	0.00							
	1-Drill Ø0.203" as per Dwg D3180								
	2-Bend one side only as per Dwg D3180								
	Identify as D3180-1								
	3-Deburr edges								
120		0.00							
	QC5- Inspect part completeness to step on W/O								
QC									
Quality Control	Memo	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59683

Wednesday, June 09, 2010 1:13:49 PM



Page 2

Item ID:	D3180-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Strut Assembly				Stop	
Start Date:	6/9/2010	Start Qty:	2.00			
Required Date:	6/24/2010	Req'd Qty:	2.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	White Gloss(Ref:4.3.5.1) per QSI005 4.3 SS 1114841	0.00							
	Powdercoat								
	Powder Coating								
	Memo	0.00							
	START TIME: 7:15 AM								
	FINISH TIME: 7:45 AM								
	OVEN TEMPERATURE: 400°C								
140 	QC3- Inspect Part Finish	0.00							
	QC								
	Quality Control								
	Memo	0.00							
150 	Small Fab	0.00							
	Small Fab								
	Small Fab								
	Memo	0.00							
	1-Assemble as per Dwg D3180								

⇒ 10/06/15 12 0

2 BR 10-6-15

⇒ m-l w/06/15 (2X)

W/O:		WORK ORDER CHANGES					
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Wednesday, June 09, 2010 1:13:49 PM



Page 3

Item ID: D3180-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut Assembly

Start Date: 6/9/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 6/24/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8-6-15

②

170



Packaging

Packaging

Identify as per dwg & Stock Location: 274

0.00

Memo

0.00

10-6-15 ② SP

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/17 JF
mr
10-6-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Wednesday, June 09, 2010 1:13:54 PM

Page 1

Work Order ID: 59683

Parent Item: D3180-041

Parent Item Name: Strut Assembly

Comments: IPP Rev:A 03.01.27 New issue KJ/RF
IPP Rev:B 07-06-28 Asper Rev B JLM

Start Date: 6/9/2010

Required Date: 6/24/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS27039-1-10 Screw		Purchased	No			100	Each	144.0000	1	2			

Location

Loc Qty

Loc Code

ST291

144

112794

44

112940

100

A1449

Purchased

No

150

Each

1,200.000

1

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Wednesday, June 09, 2010 1:13:54 PM

Page 2

Work Order ID: 59683

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Parent Item Name: Strut Assembly

Comments: IPP Rev:A ☐ 03.01.27 ☐ New issue ☐ KJ/RF
IPP Rev:B 07-06-28 Asper Rev B JLM ☐

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Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2022-101

Manufactured

No

150

Each

201.0000

2

4



Spacer



10-6-150

Location

Loc Qty

Loc Code

ST504

201

45885

1

50746

100

~~52325~~

100

7

D2690-6

Manufactured

No

150

Each

12.0000

1

2



Lanyard Assembly



10-6-155

20

Location

Loc Qty

Loc Code

ST021

12

~~58375~~

12

8

M304TR0.750W.065

Purchased

No

150

f

72.0000

3.5833

7.543789



304 RD Tube .750 x .065W



Location

Loc Qty

Loc Code

MAT017

72

114002

72

8.5 So 10/06/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

Work Order ID: 59683



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Parent Item Name: Strut Assembly

Start Date: 6/9/2010

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Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21042L3		Purchased	No			150	Each	3,346.000	1	2			
										10-6-	15	22	50
Nut													

Location

Loc Qty

Loc Code

ST300

3346

113537

18

113644

3

~~114523~~

825

114718

500

114784

2000

Wednesday, June 09, 2010 1:13:54 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DART

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

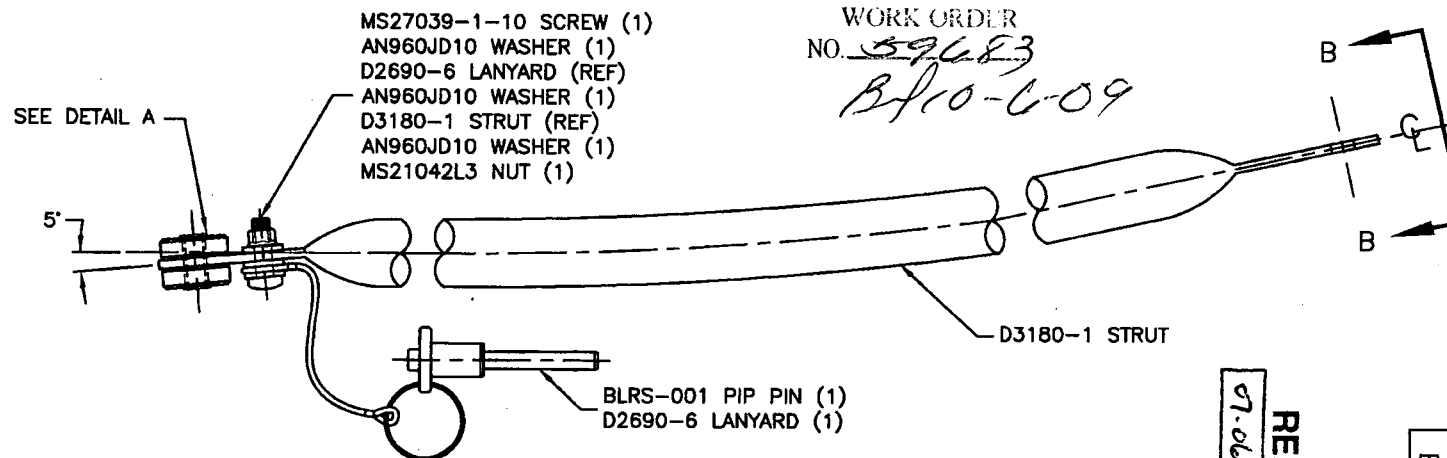
SUBJECT TO AMENDMENT

WITHOUT NOTICE

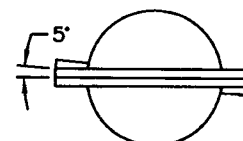
WORK ORDER

NO. 59683

B-10-6-09

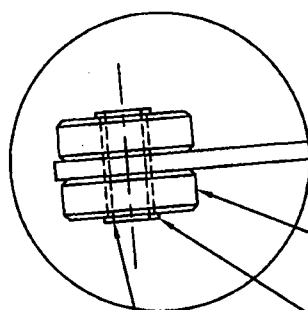


D3180-041 STRUT ASSEMBLY



VIEW B-B

SCALE 1:1



D2022-101 SPACER
(2 PLACES)

SWAGE D2022-101 SPACERS ONTO
D3180-1 STRUT USING A1449 GROMMET
(1 PLACE)

A1449 GROMMET
(REF)

DETAIL A

SCALE 1:1

RELEASED
07.06.08

DESIGN	DRAWN BY	DART AEROSPACE LTD	
		HAMKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>SC</i>	DRAWING NO. D3180	REV. B
DATE 07.05.23		TITLE STRUT ASSEMBLY	SHEET 1 OF 2
			SCALE 1:2
A	03.01.06	NEW ISSUE	
B	07.05.23	CURVE ADDED	

QTY	PART NUMBER	DESCRIPTION
-041		
X	D3180-041	STRUT ASSEMBLY
1	D3180-1	STRUT
1	D2690-6	LANYARD
2	D2022-101	SPACERS
3	AN960JD10	WASHER
1	MS27039-1-10	SCREW
1	BLRS-001	PIP PIN
1	MS21042L3	NUT
1	A1449	GROMMET

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

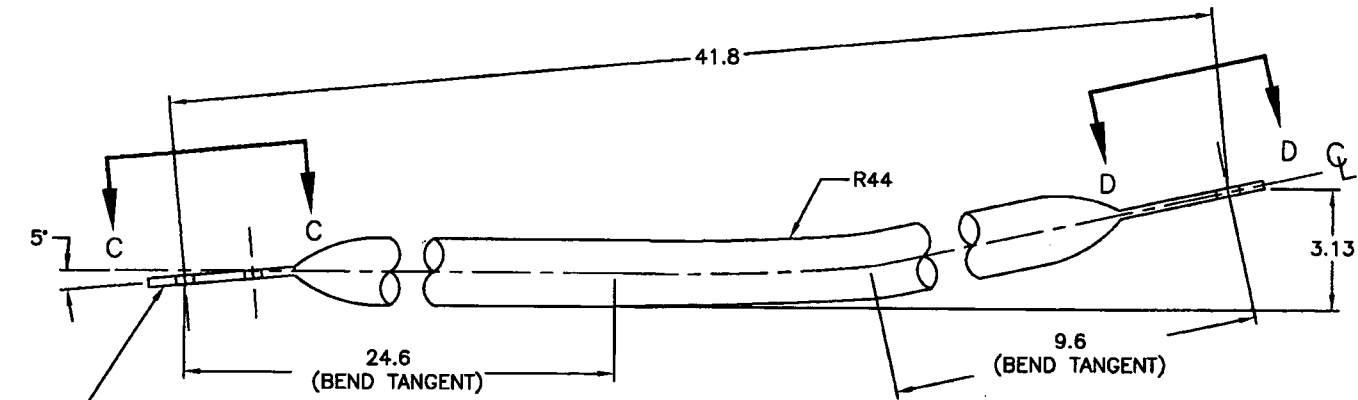
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.23	DRAWING NO.	D3180	REV. B
		TITLE	STRUT ASSEMBLY	SHEET 2 OF 2
		SCALE	1:2	



D3180-1 STRUT

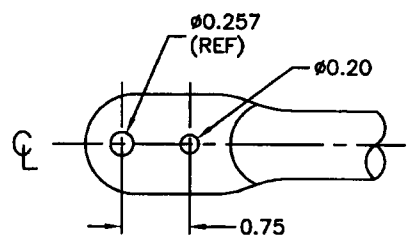
USE PUNCH DT8117
BOTH ENDS
(DIMS PER SPEC. CONTROL DWG D2638)

w/o 5968?

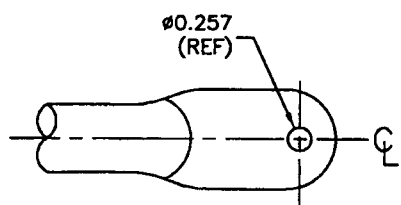
RELEASED
07.05.23

NOTES

- 1) MATERIAL: AISI 304/316/318 SS TUBE,
Ø0.75 X 0.065 WALL
(REF. DART SPEC M304TRO.750W.065)
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART
QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH PART P/N "D3180-041" USING
FINE POINT PERMANENT INK MARKER



VIEW C-C



VIEW D-D

W/O:		WORK ORDER CHANGES					
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